

FIG. 1

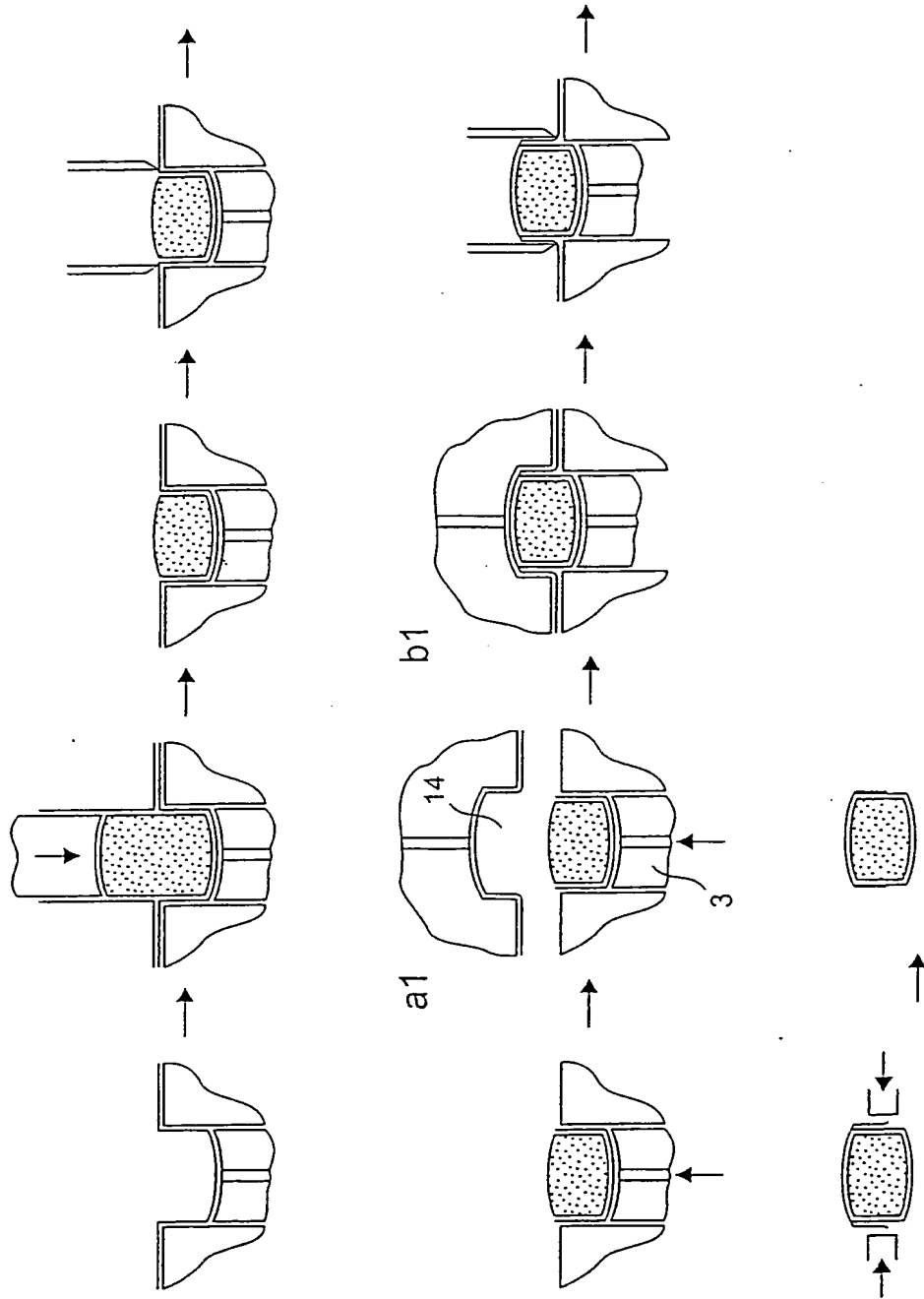


FIG. 2

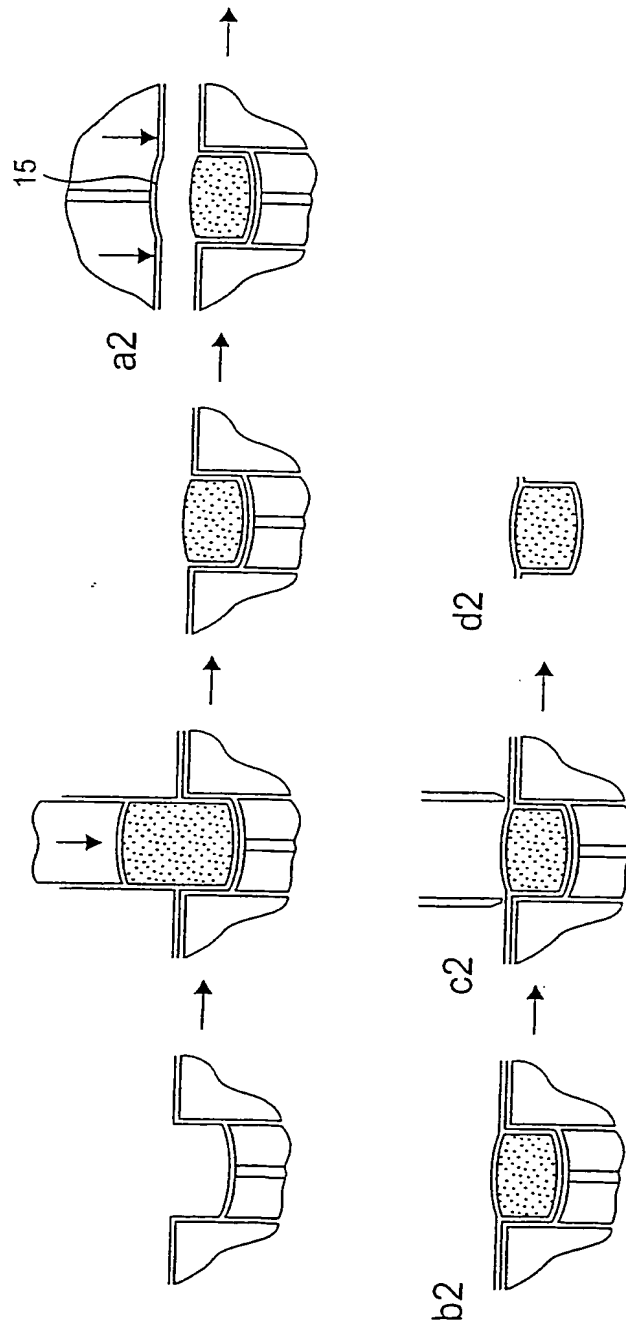


FIG. 3

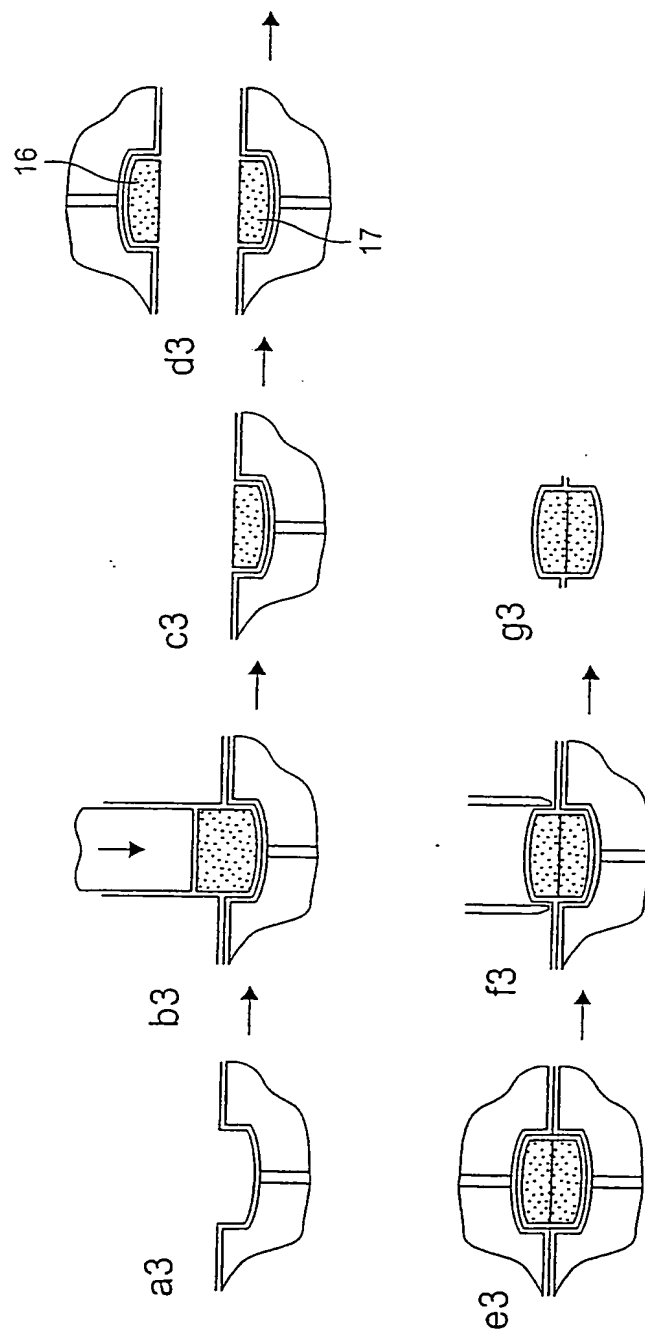


FIG. 4

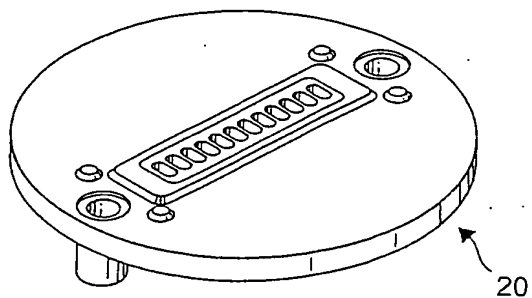


FIG. 5A

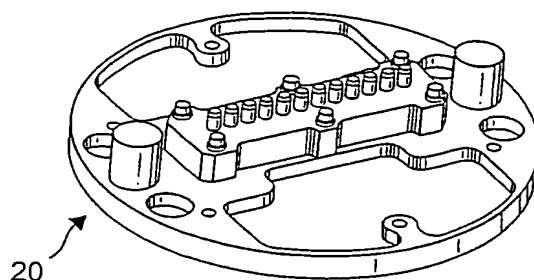


FIG. 5B

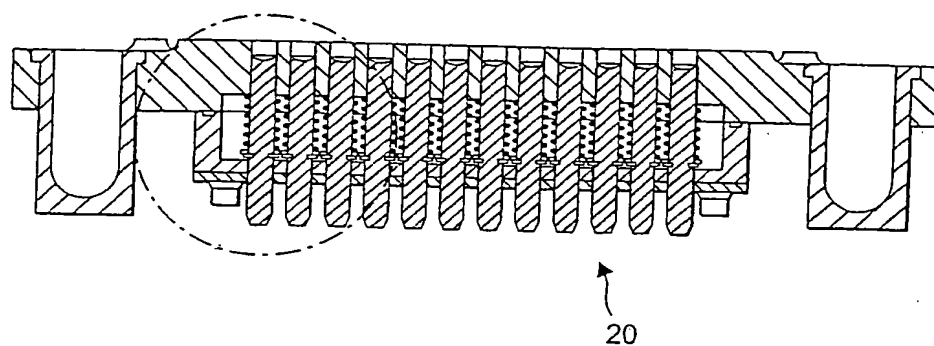


FIG. 6A

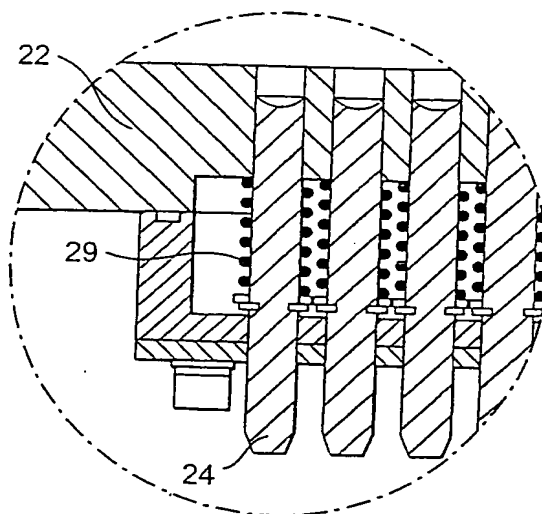


FIG. 6B

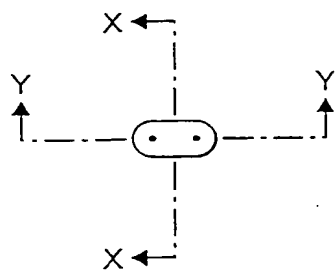


FIG. 7C



FIG. 7E

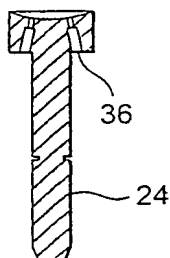


FIG. 7D

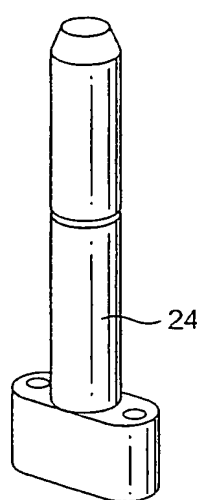


FIG. 7A

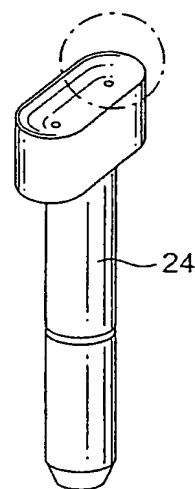


FIG. 7B

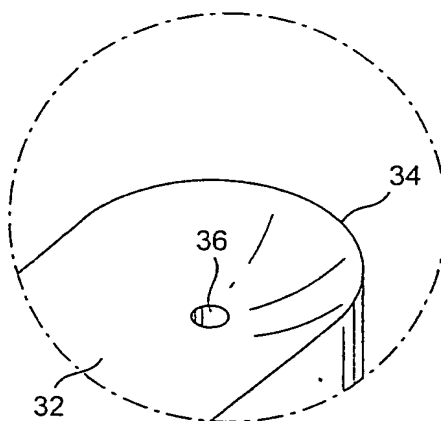
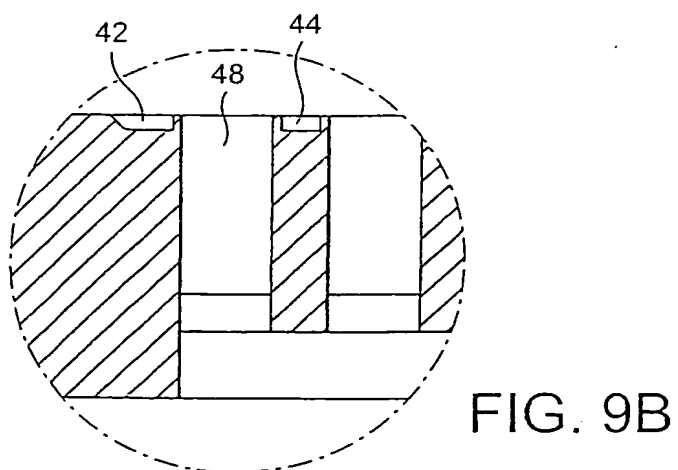
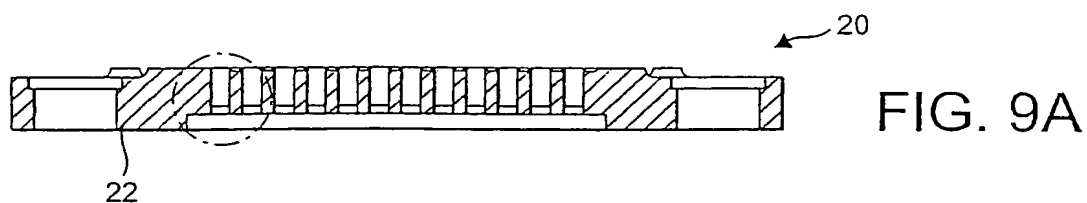
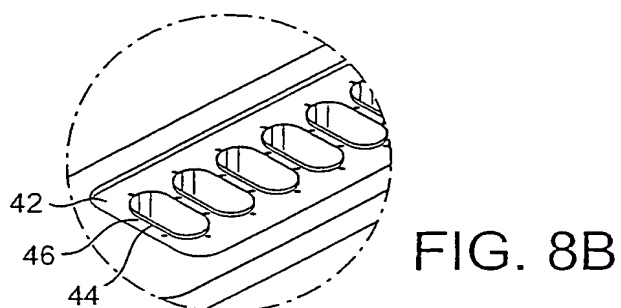
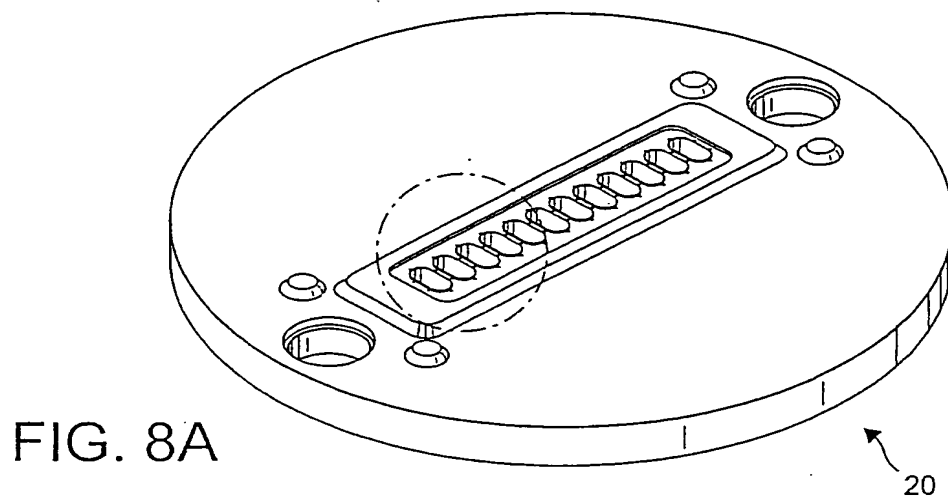


FIG. 7F



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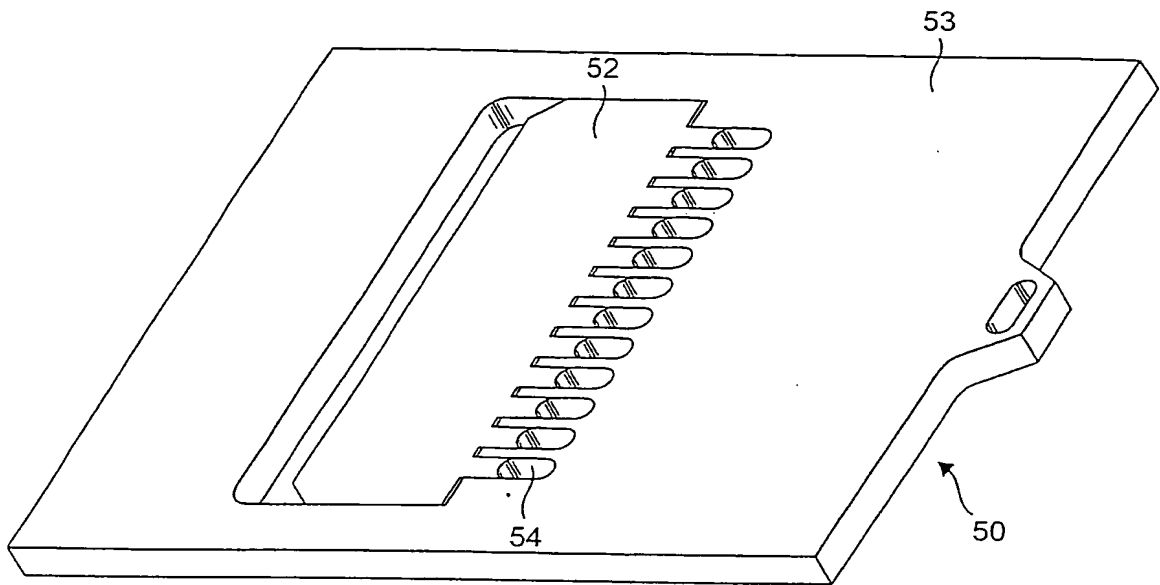


FIG. 10

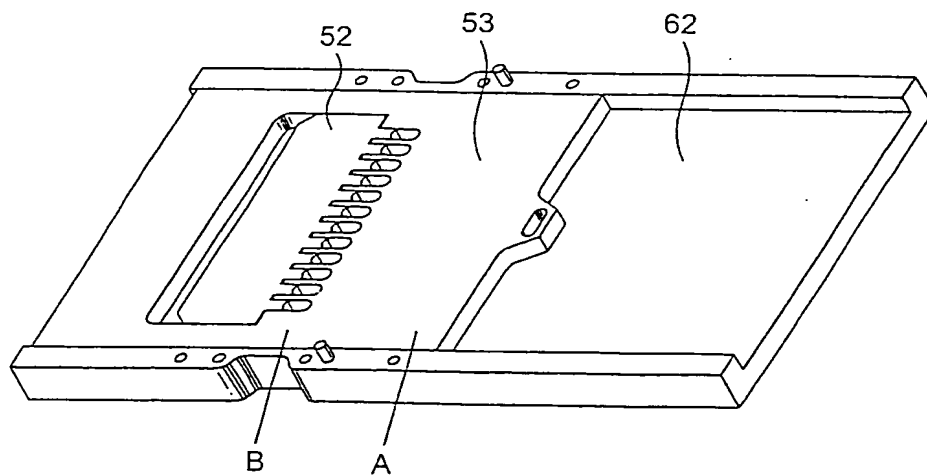


FIG. 11



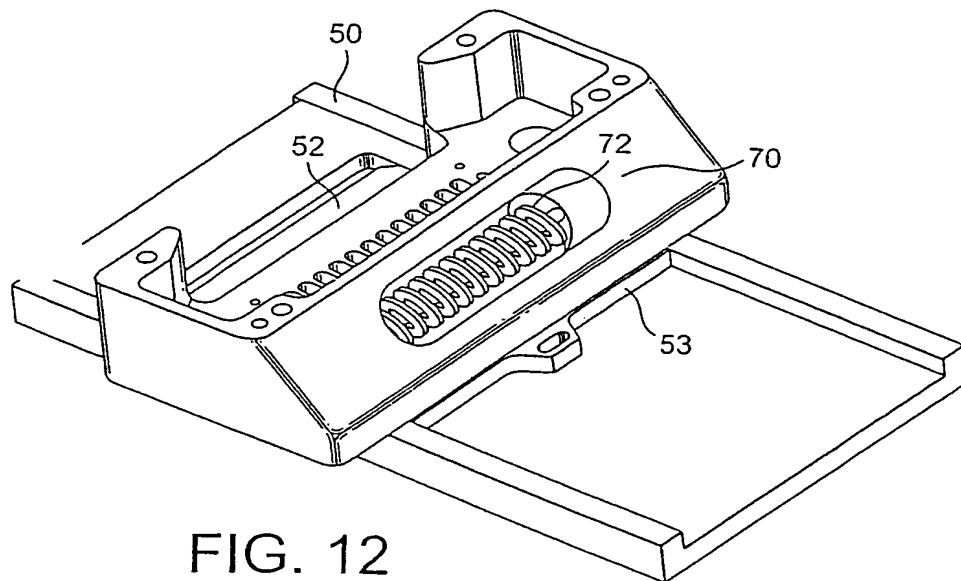


FIG. 12

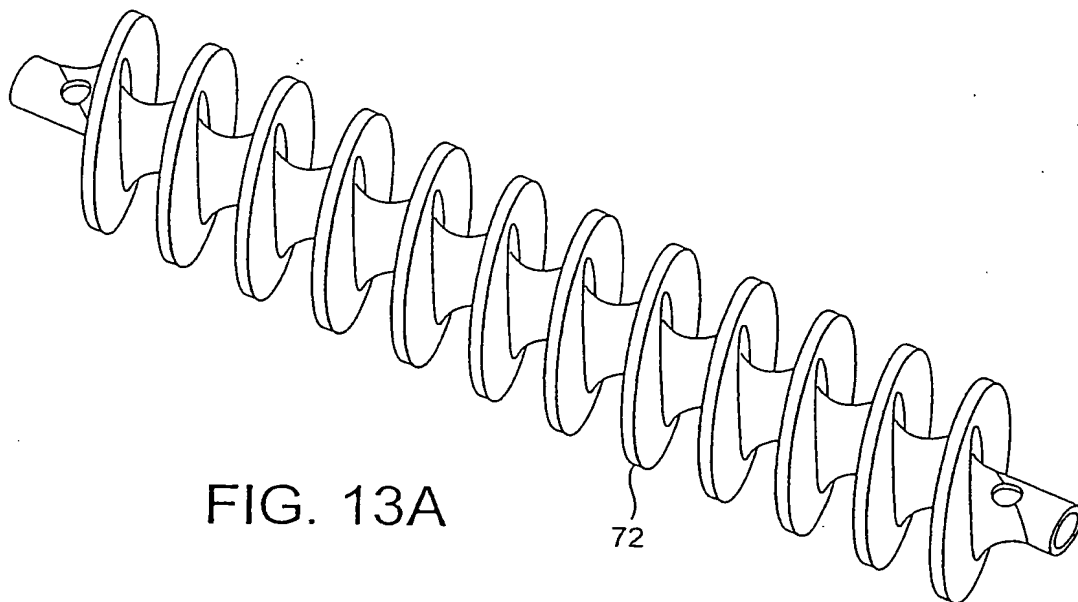


FIG. 13A

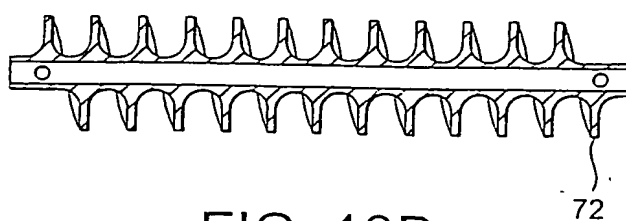


FIG. 13B

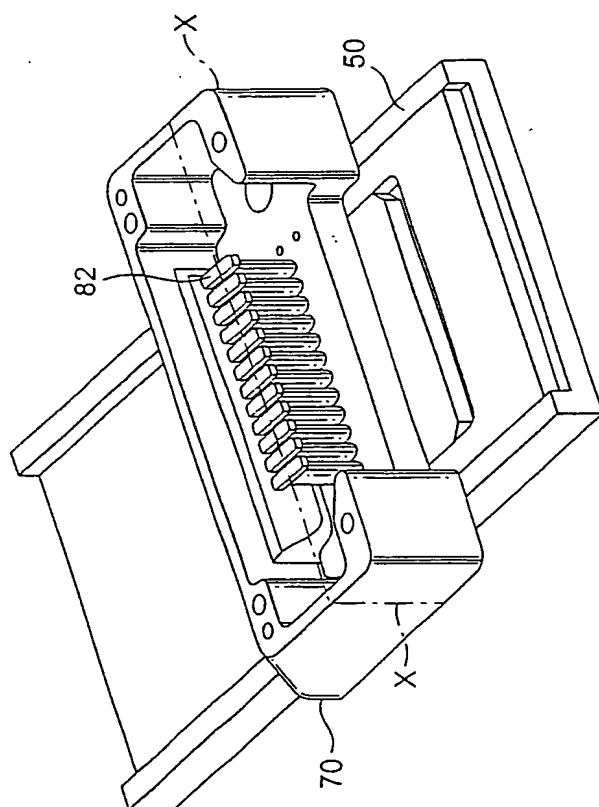


FIG. 14A

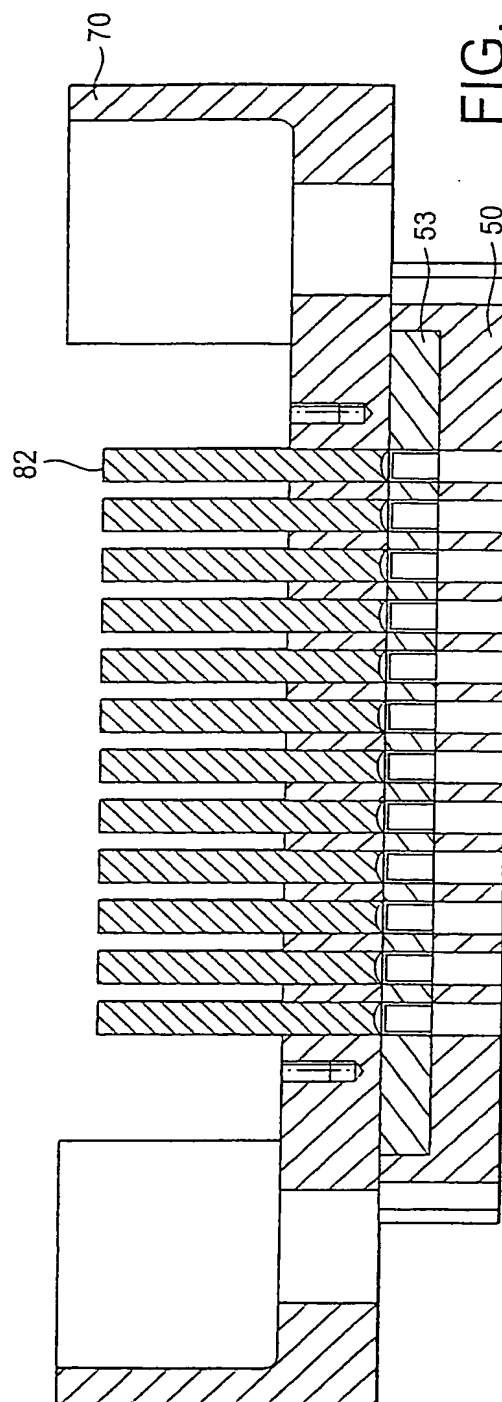


FIG. 14B

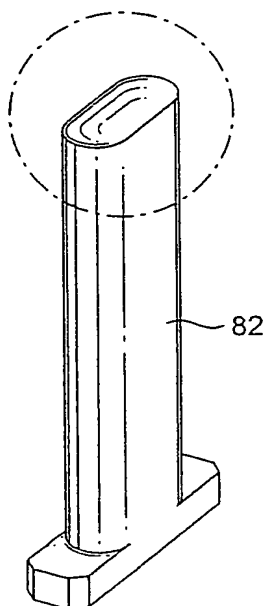


FIG. 15A

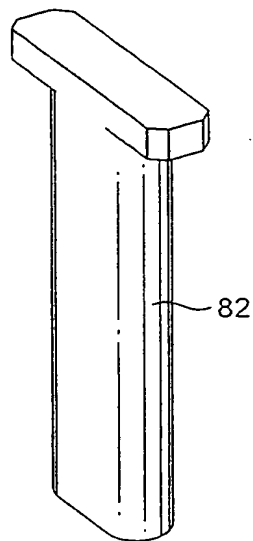


FIG. 15B

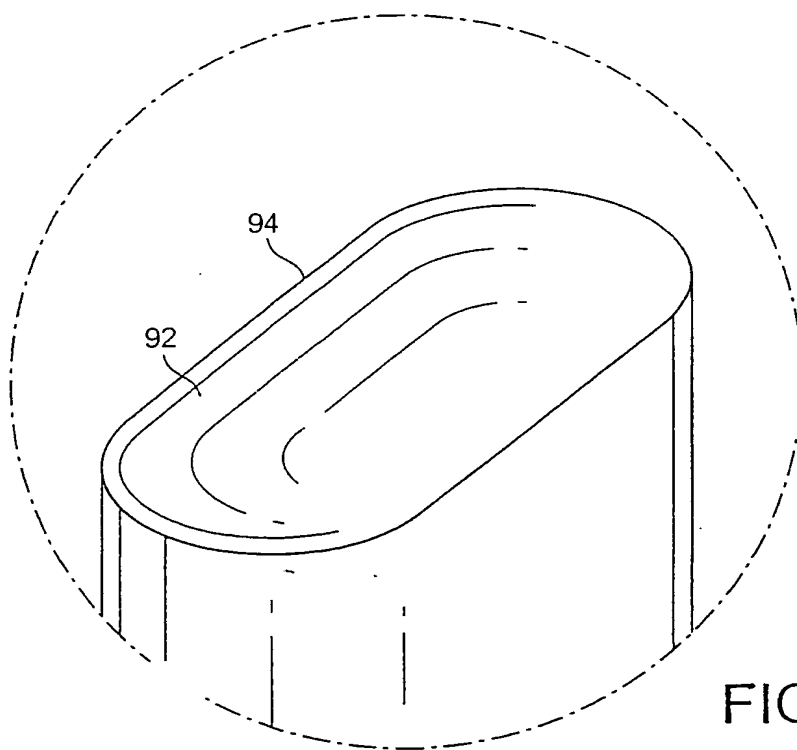


FIG. 15C

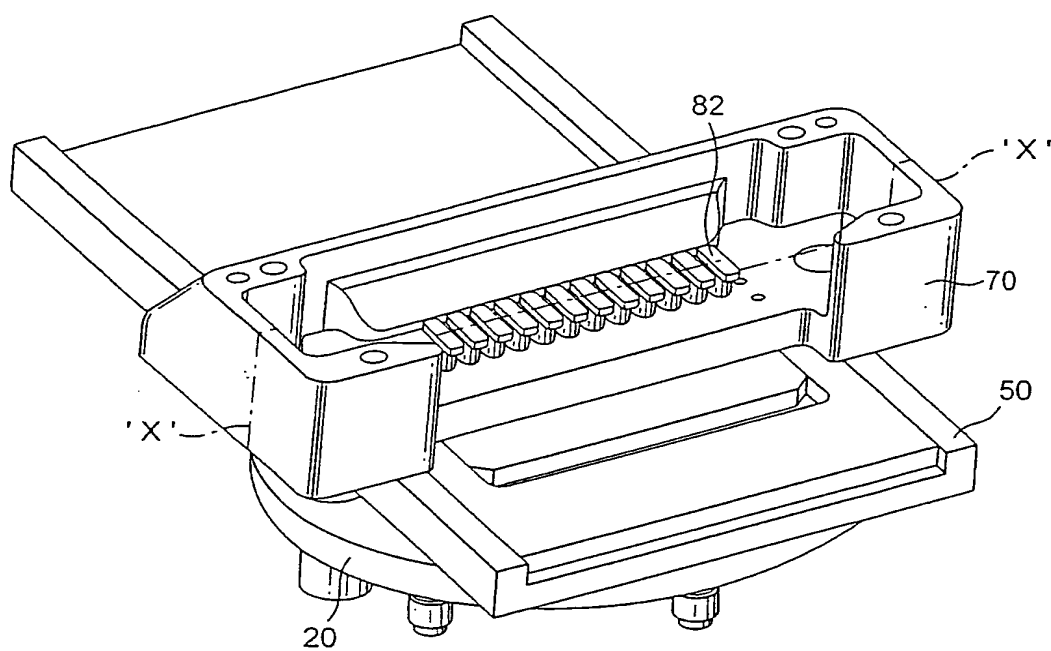


FIG. 16A

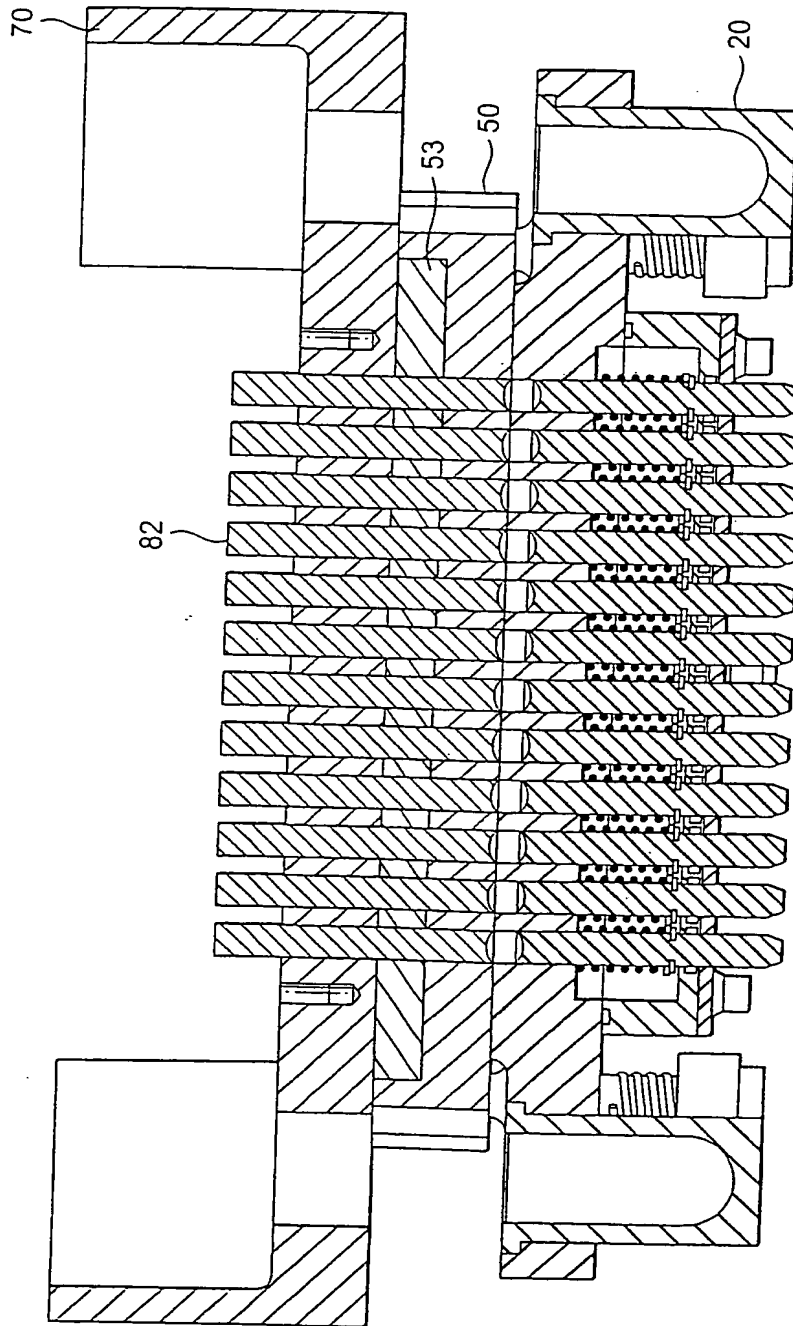


FIG. 16B

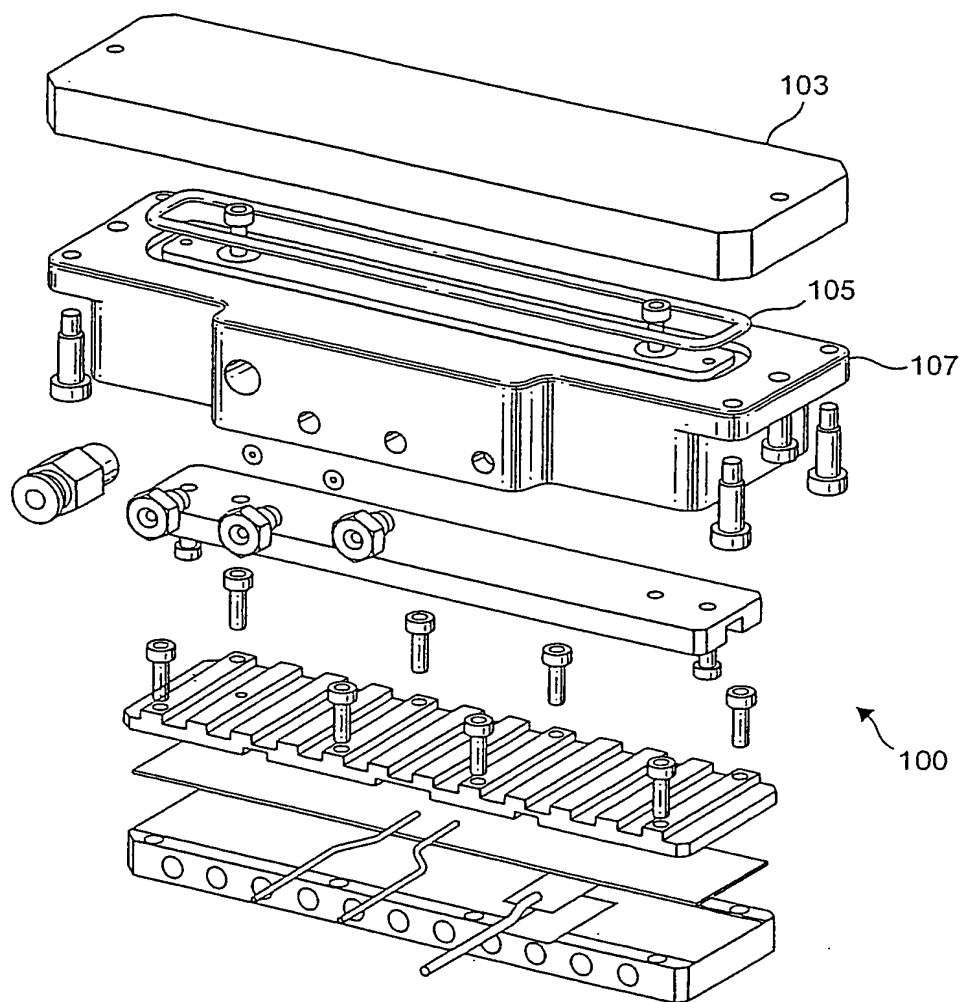


FIG. 17A

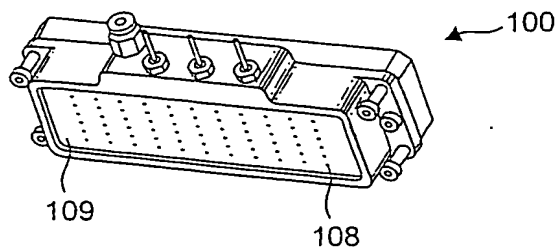


FIG. 17B

FIG. 18

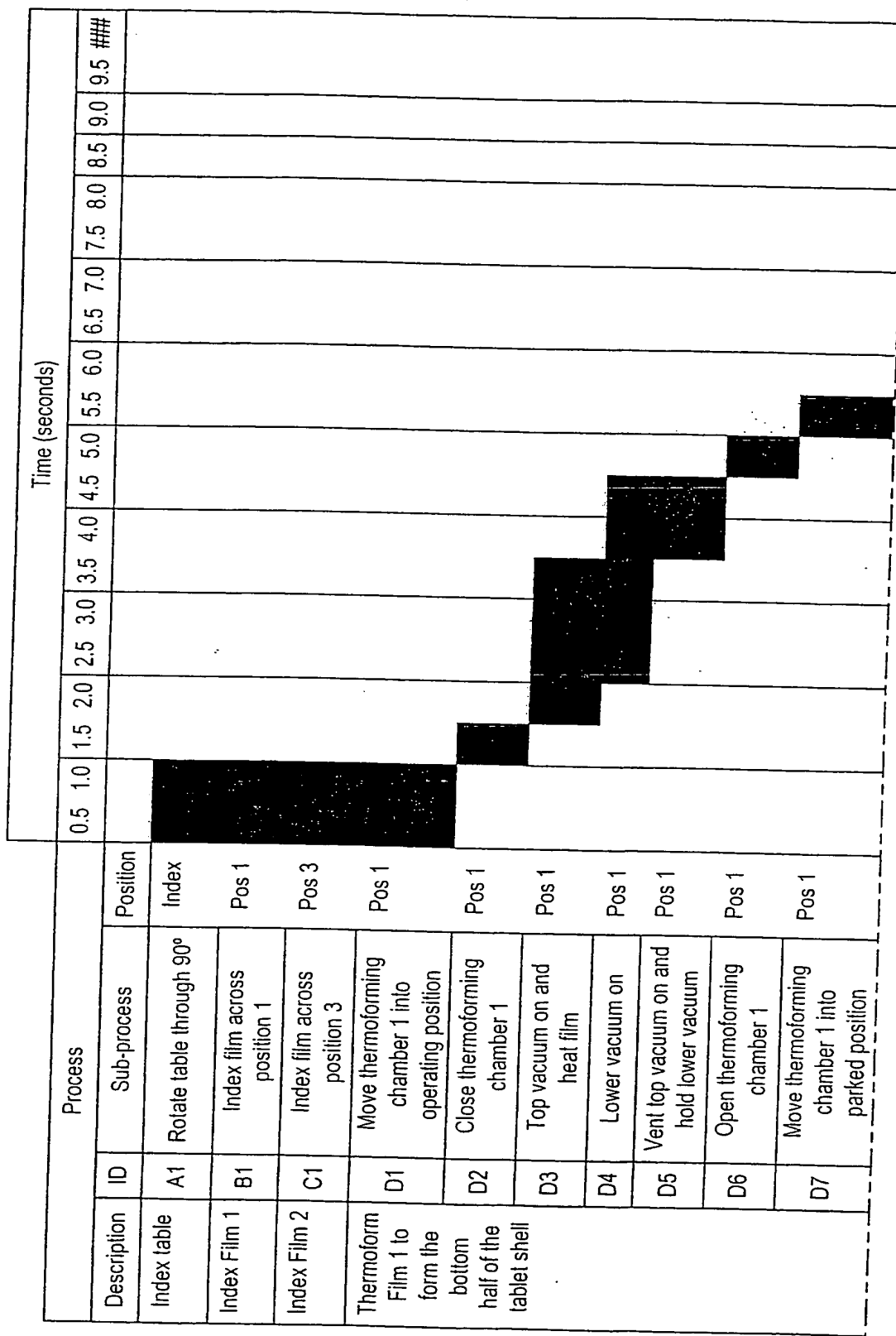


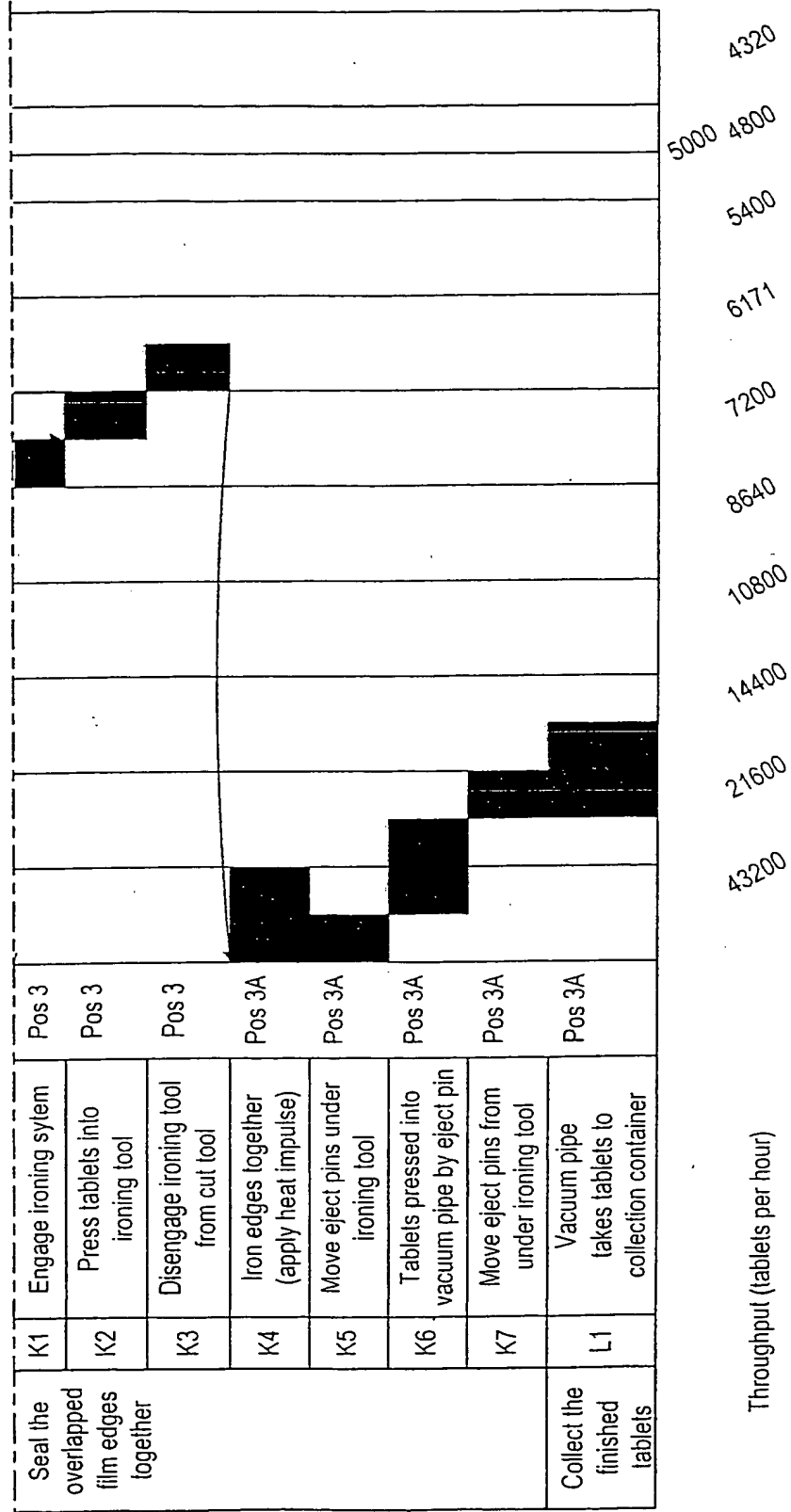
FIG. 18 cont'd

Task	Activity	Position
Fill and compact a measured dose of powder into the shell	E1 Measure out powder	Pos 1
	E2 Move top tool assembly into engagement with tablet platen	Pos 1
	E3 Place powder into/over tablet shell	Pos 1
	E4 Compact powder into shell	Pos 1
Cut and remove the waste film from around the filled shell	F1 Move lower piston to cut position	Pos 1
	F2 Cut	Pos 1
	F3 Move top tool assembly out of engagement with tablet platen	Pos 1
	F4 Remove waste film	Pos 1
Apply glue to film 2	Ready to index table	
	G1 Move lower piston to 2nd thermoforming position	Pos 2
	G2 Apply glue	Pos 2



Ready to index table	
H1	Move thermoforming chamber 2 into operating position
H2	Move lower piston to 2nd thermoforming position
H3	Close thermoforming chamber 2
H4	Top vacuum on and heat film
H5	Lower vacuum on
H6	Vent top vacuum on and hold lower vacuum
H7	Open thermoforming chamber 2
J1	Engage cutting system
J2	Cut
J3	Disengage cutting system
J4	Remove waste film
	Ready to index table

FIG. 18 cont'd



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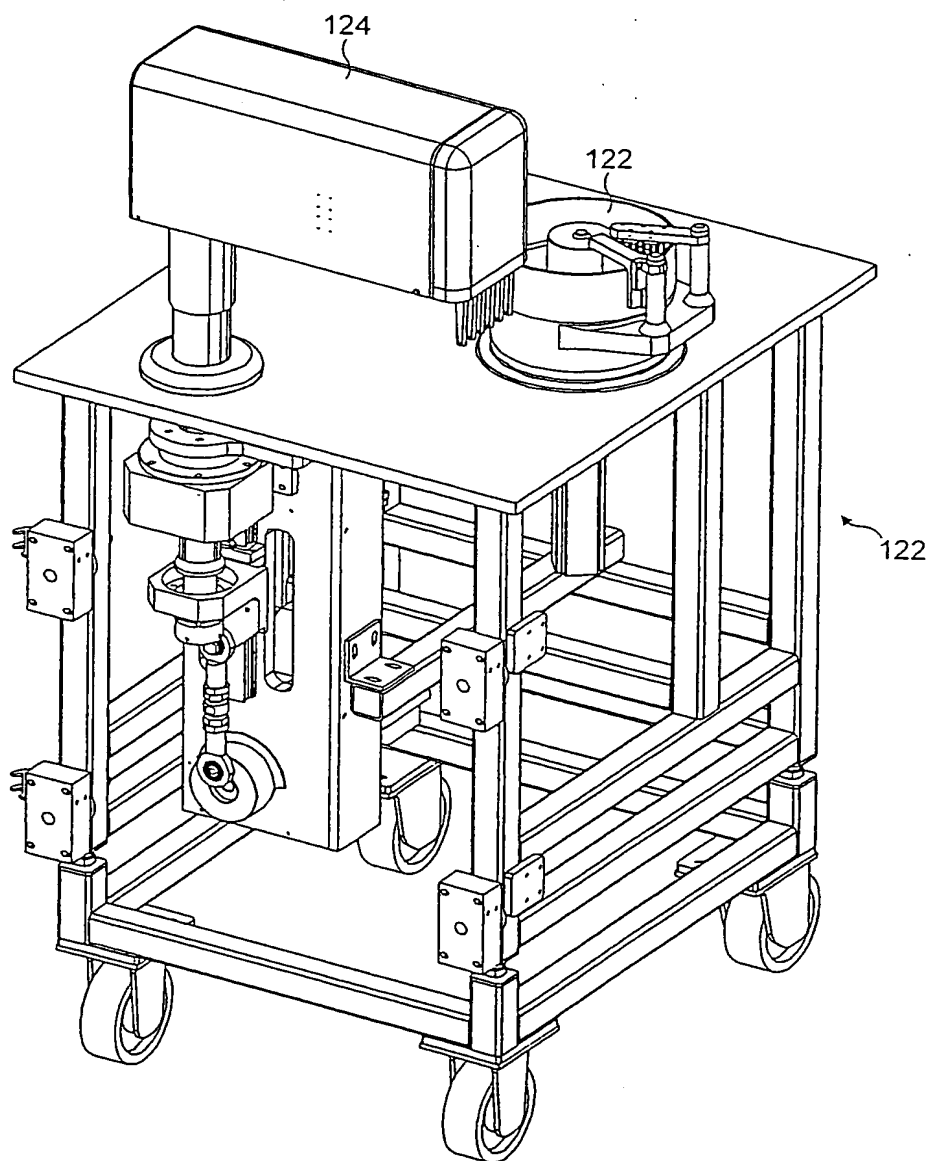


FIG. 19A

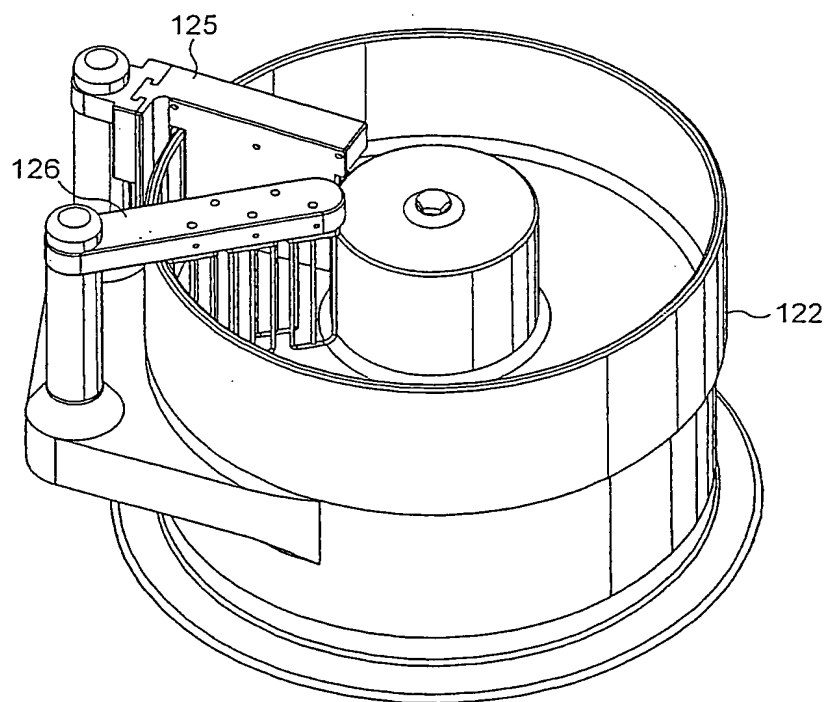


FIG. 19B

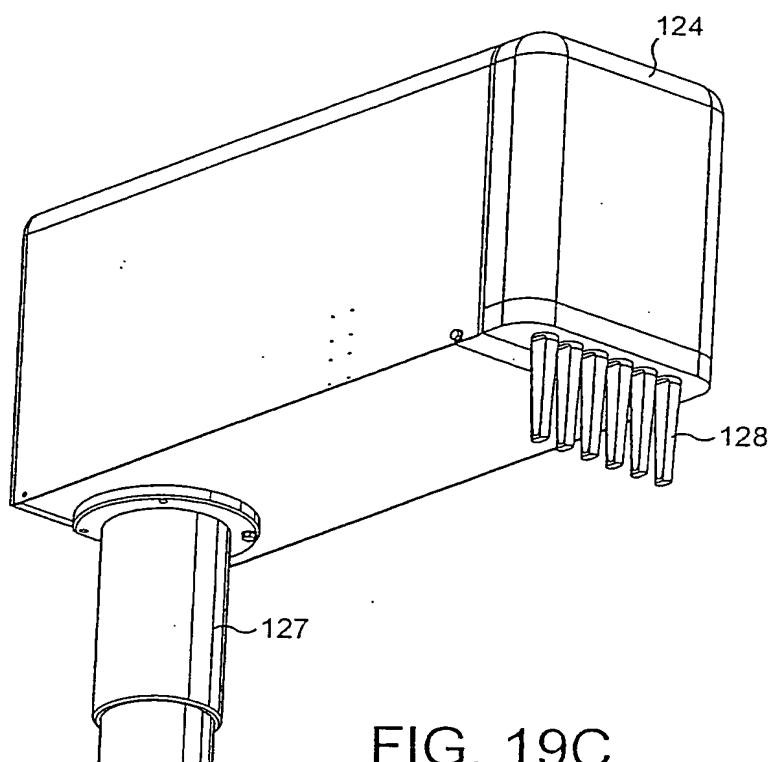


FIG. 19C

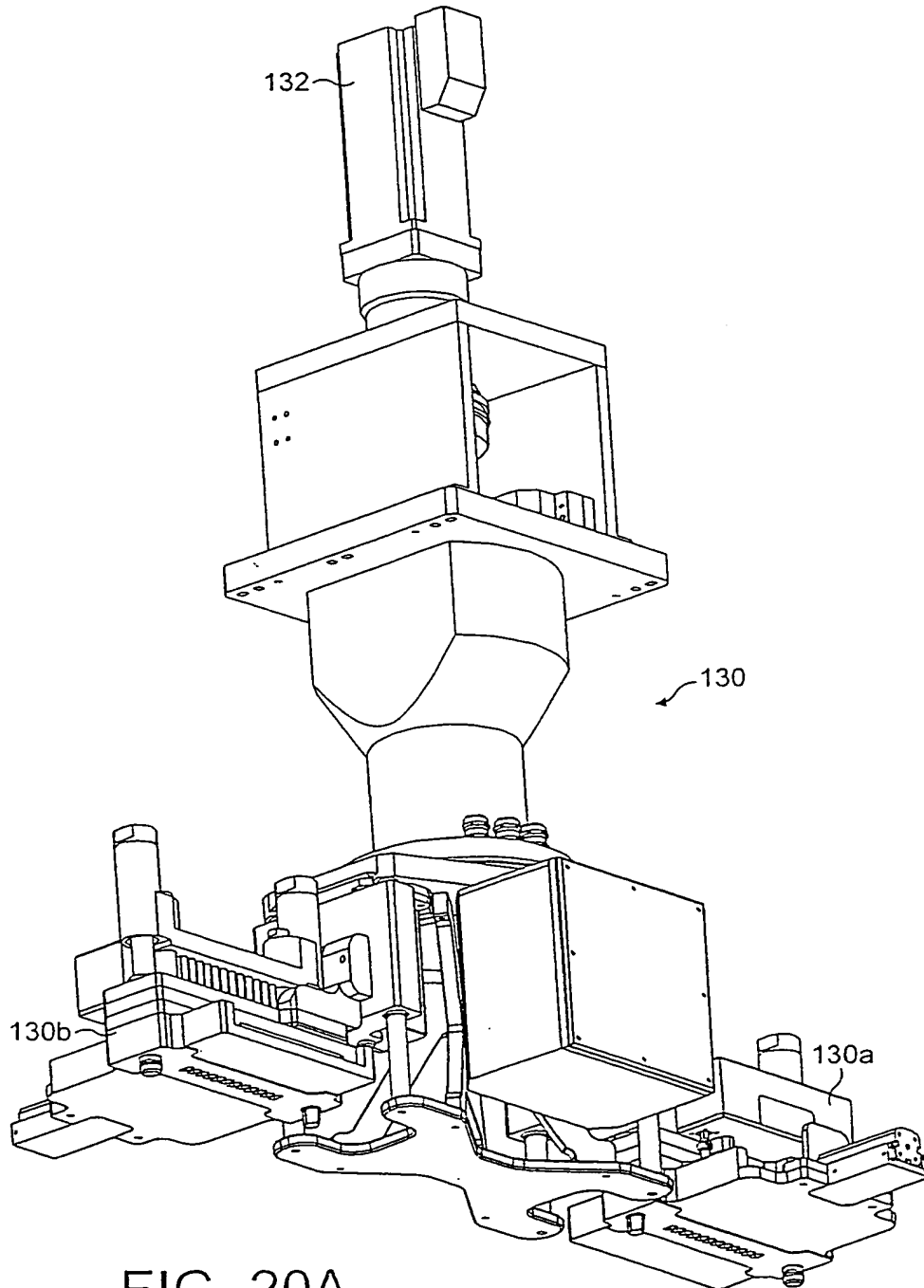


FIG. 20A

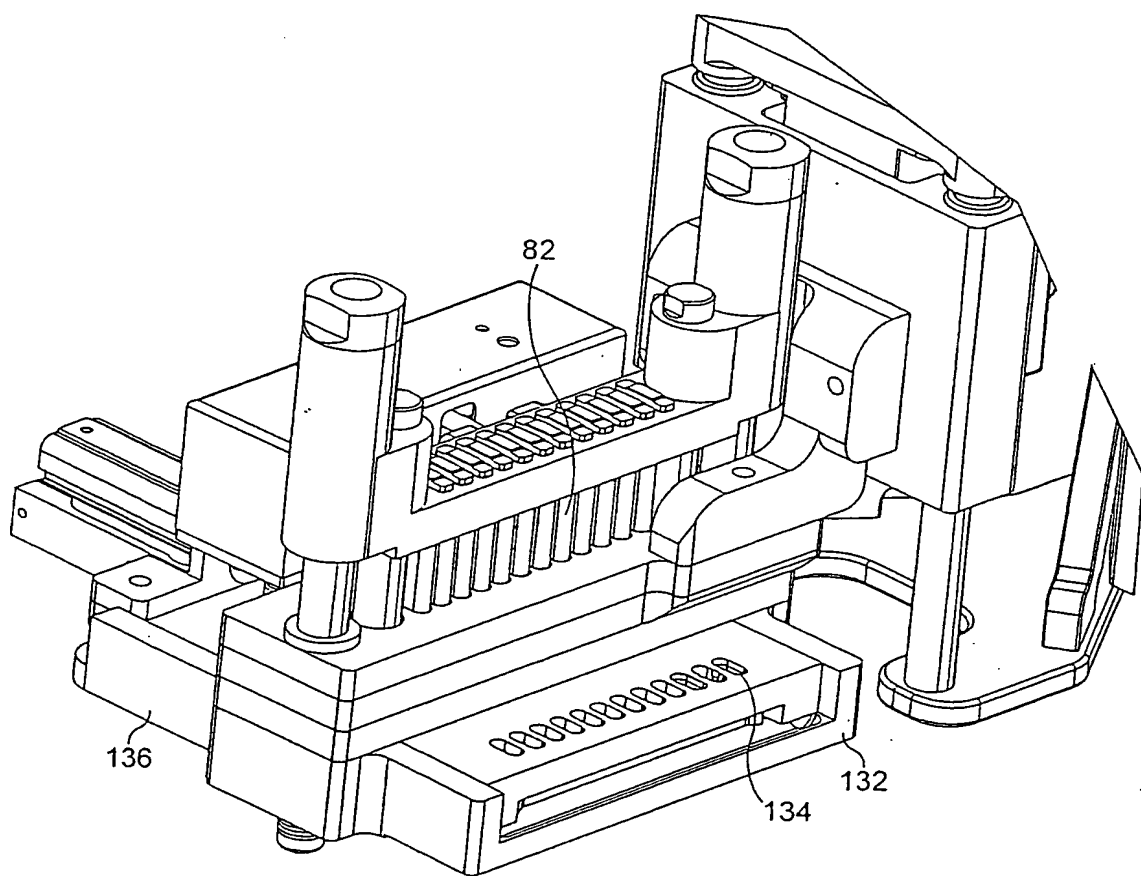


FIG. 20B

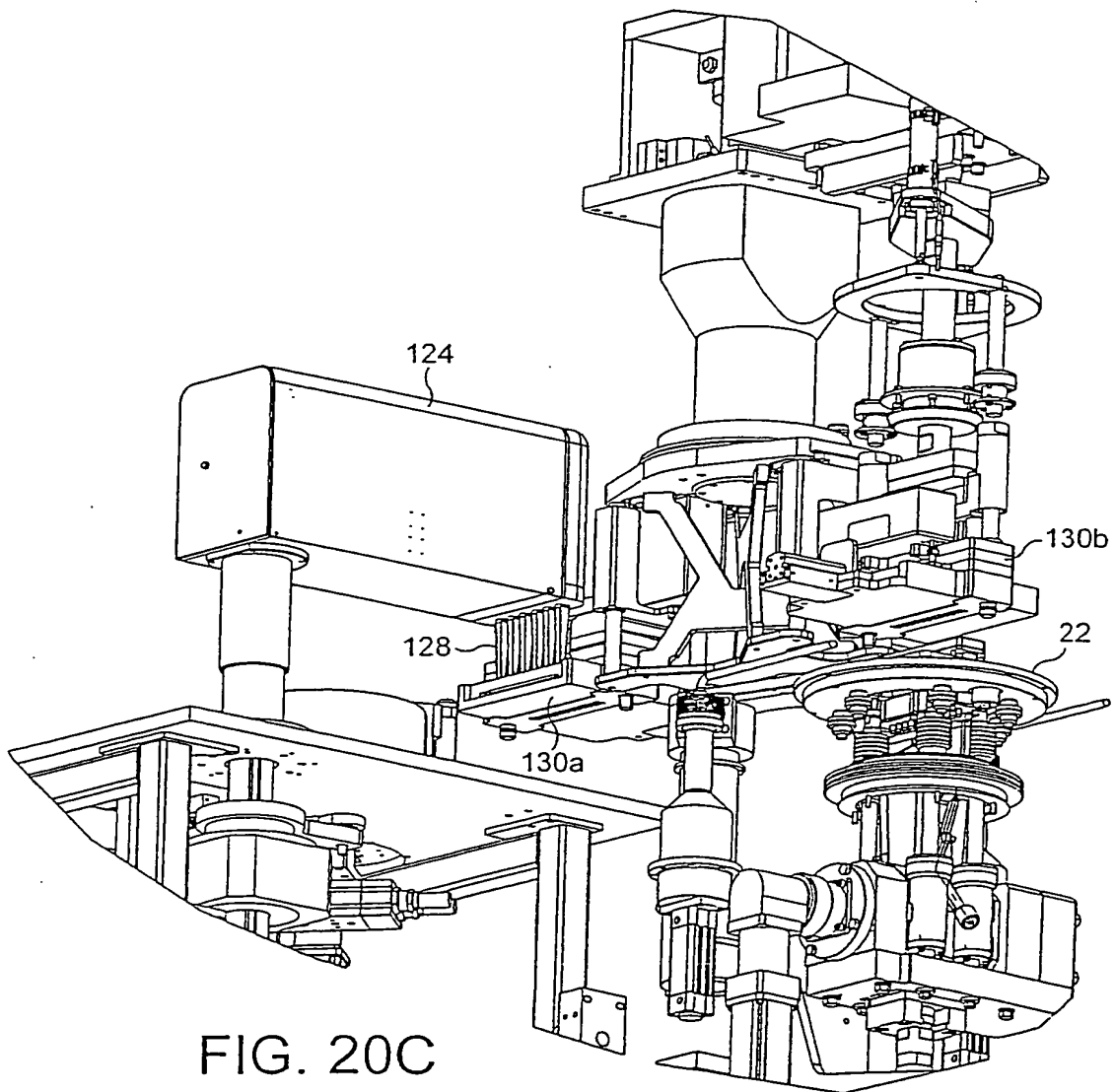


FIG. 20C



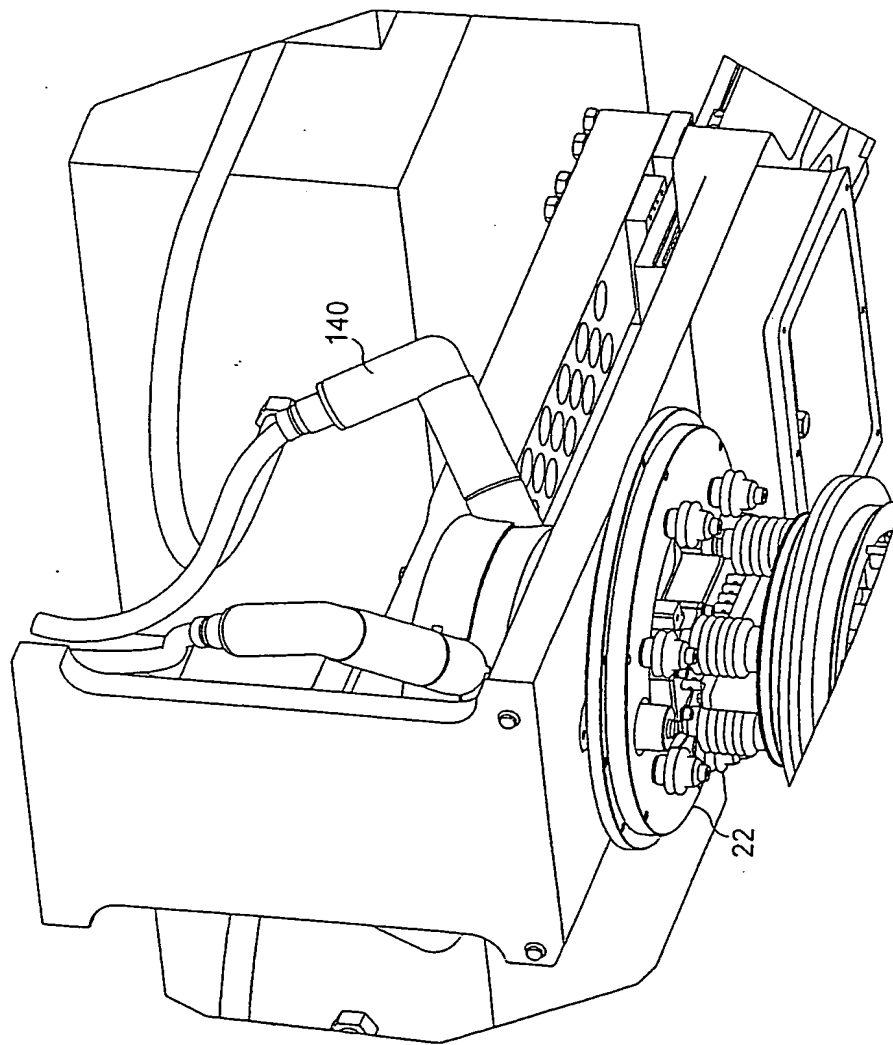


FIG. 21

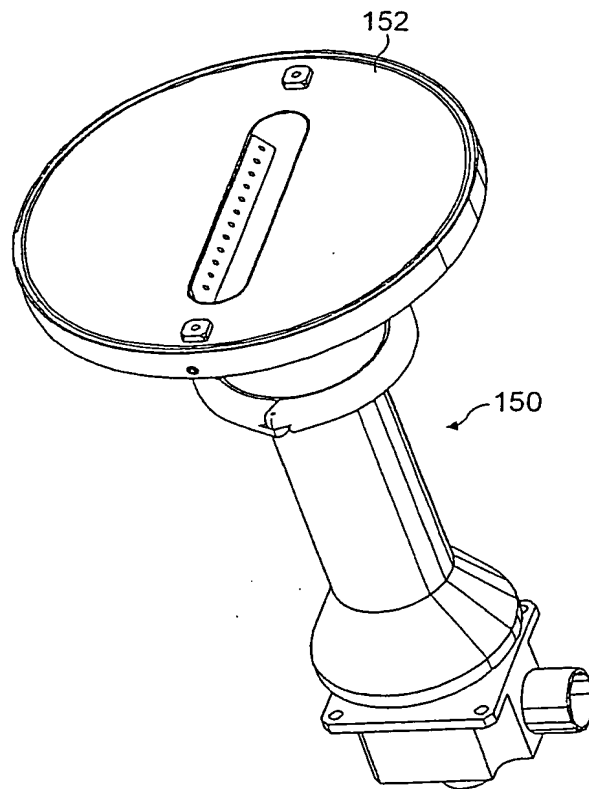


FIG. 22

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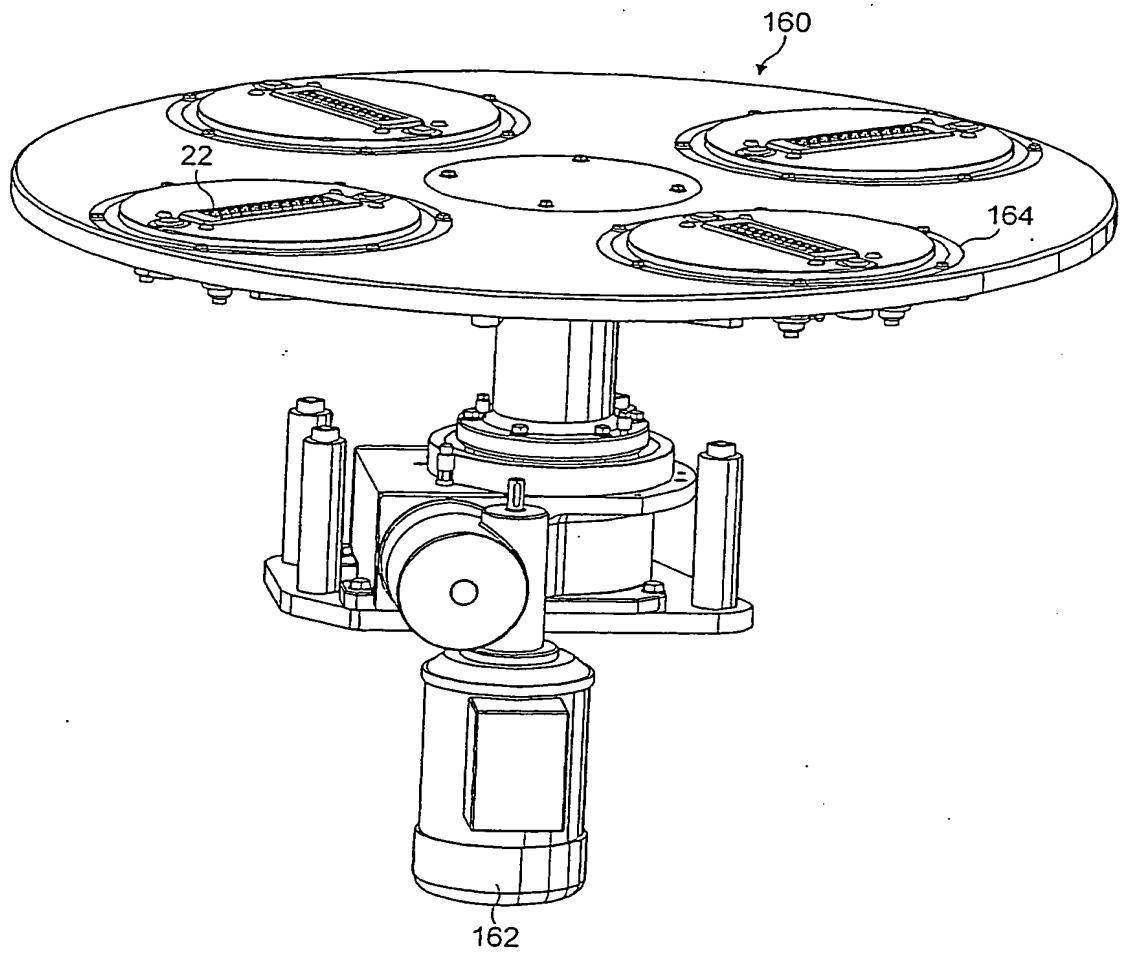


FIG. 23

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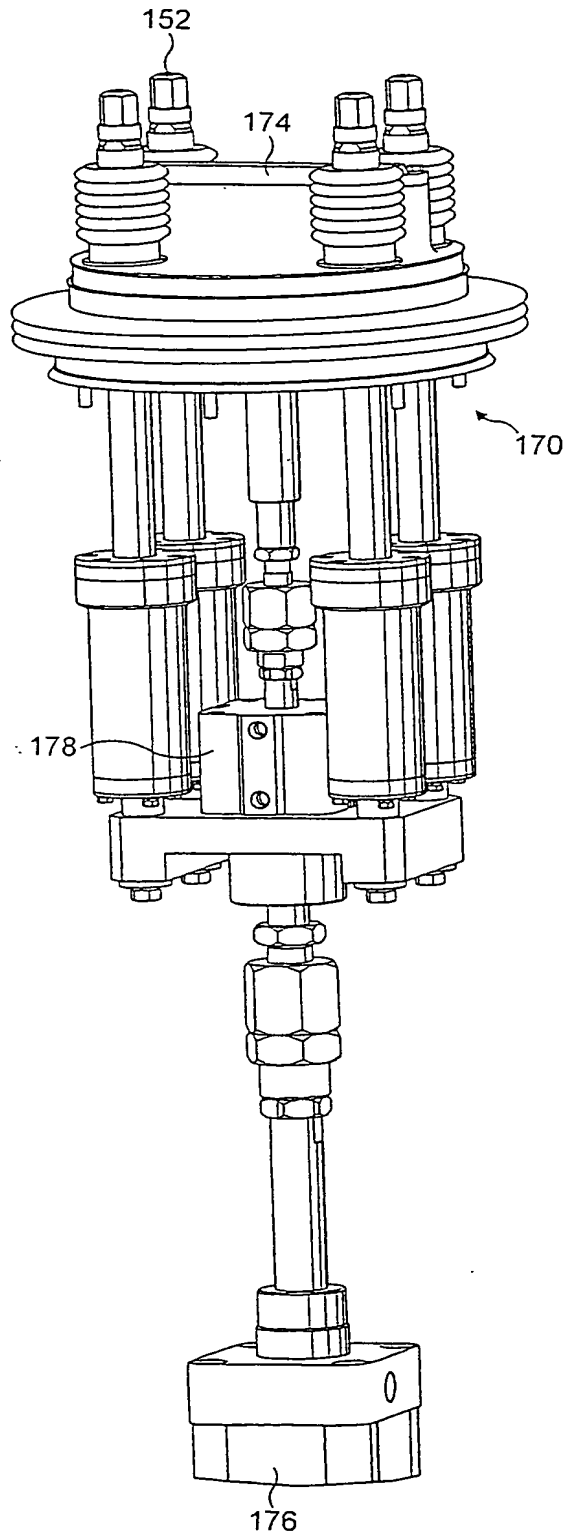


FIG. 24

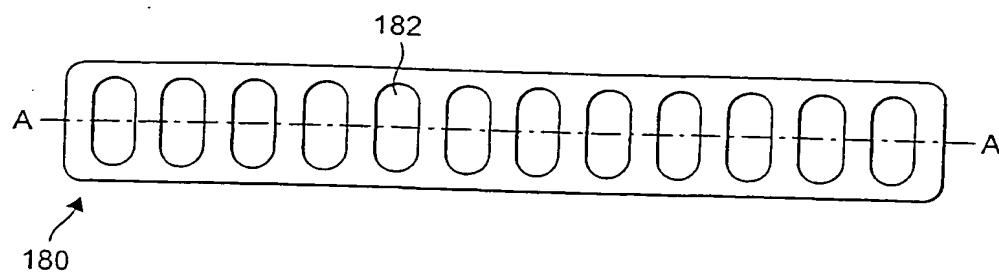


FIG. 25A

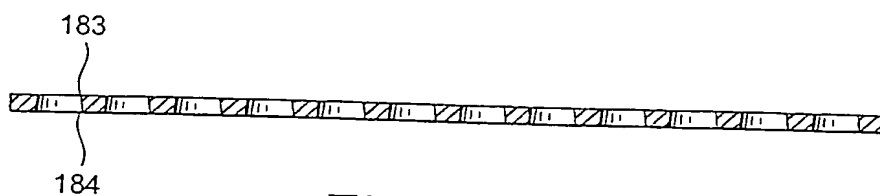


FIG. 25B

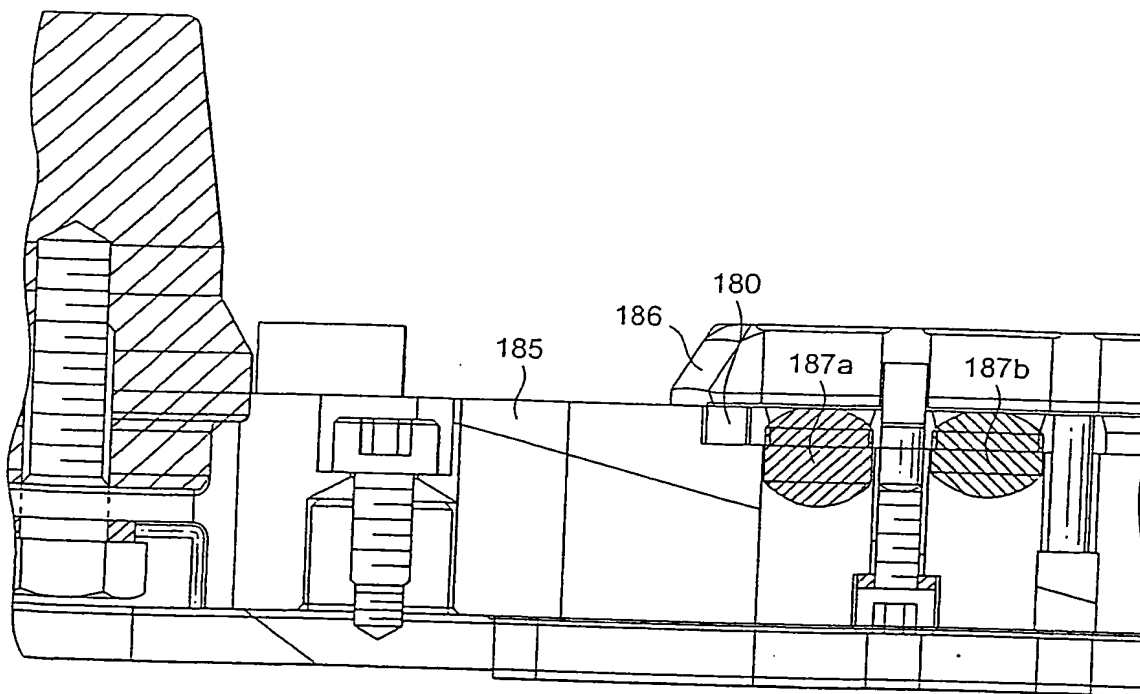


FIG. 25C

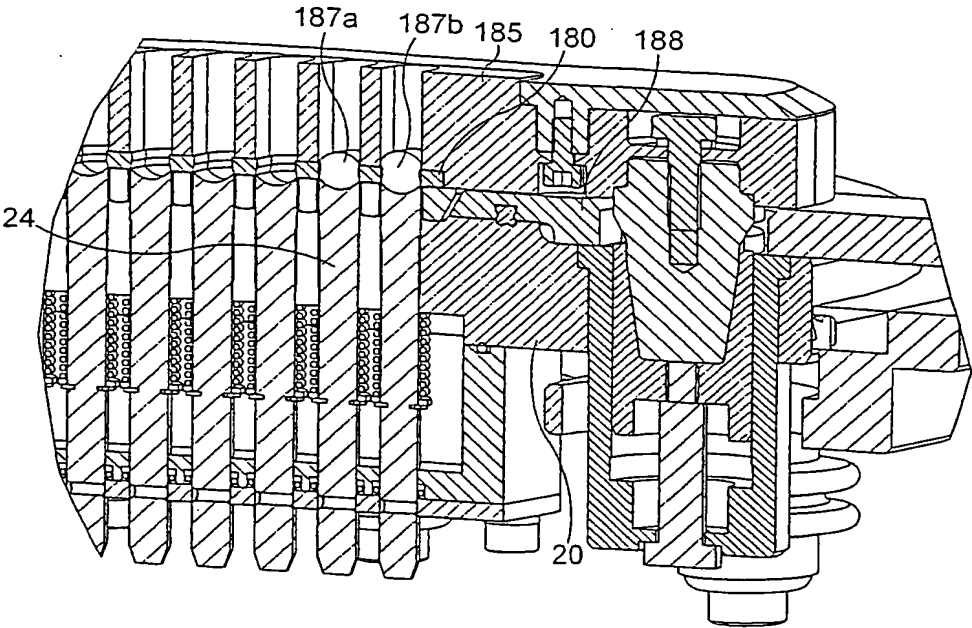


FIG. 25D

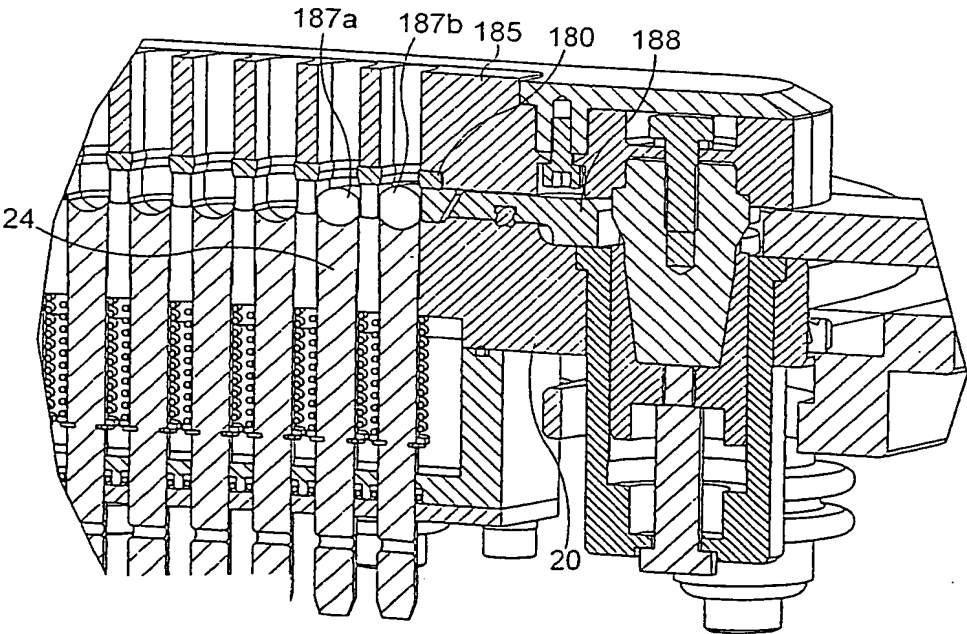


FIG. 25E